

Work Order ID 50828

July 23, 2009 7:35:47 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 07/23/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/31/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 09-07-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A on W/O 51022

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

110-7-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 ~~0~~ - AUM9-7-23

8016723 @

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R Aluminum Rod

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R Aluminum Rod

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE 09/07/23

BE 09/07/23

BE 09/07/30

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

=> S 07/20/20

(XL)

φ

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> S 07/30/20

(XL)

φ

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 07-08-7

(D)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--



Powdercoat

Memo

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

11:50AM
320°C
12:20PM

M112148 09-08-04 (X) [Signature]

190	QC3- Inspect Part Finish	0.00							
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QC

Memo

Quality Control

OK 09-08-04. (D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R [] [] [] Sikaflex-291 [] m11557 [] []
Sikaflex expire date: 10/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R [] [] [] Sikaflex-291 [] m11557 [] []
Sikaflex expire date: 10/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: m112106

(X1)

UMD 09/08/05

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

⇒ 50828



220



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

PPP 51022

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

50828
12

W 08.08.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

July 23, 2009 7:35:46 AM

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Work Order ID: 50828

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Start Date: 07/23/2009

Required Date: 07/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2580-1RevD

Manufactured

No

110

Each

1.0000

1.0000



205 Skidtube bent detail

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

48616

1

140

Each

168.0000

1.0000

D2576-3RevG

Manufactured

No



Step (maching detail)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

168

43504

65

46661

103

140

Each

512.0000

20.0000

D2579RevE

Manufactured

No



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

512

43988

4

46434

4

46956

12

47797

438

48272

54

D B5070

119-7-23

1 BE 09/07/23

20 BE 09/07/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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July 23, 2009 7:35:46 AM

Work Order ID: 50828

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 07/23/2009

Required Date: 07/31/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2855RevA		Manufactured	No			200	Each	15.0000	1.0000			

Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

15

10360

2

35663

7

41340

1

42343

3

42806

2

(X1)

und 09/08/05

AN3-5A

Purchased

No

200

Each

2,562.000

2.0000

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2562

100188

246

105057

2246

15205

70

(X2)

und 09/08/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L		Purchased	No			200	Each	7,073.000	2.0000			



Washer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	7157	
101291	16	
104885	153	
105793	236	
109632	1752	
110985	5000	

x2 MD 09/08/05

Main Warehouse

ST182	-84	
109632	-84	

ALS7-1032-130

Purchased

No

200

Each

3,850.000

50.0000



Insert

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	3850	
108606	52	
111529	1798	
111779	2000	

110511

x50 MD 09/08/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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July 23, 2009 7:35:46 AM

Page 4

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3C4A Purchased No 200 Each 152.0000 50.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

112082

152

152

AN960C10L

Purchased

No

200

Each

4,758.000 50.0000



washer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

4758

103585

100

112116

4658

X50 MTD 09/08/05

X50 MTD 09/08/05

July 23, 2009 7:35:46 AM

Shop Packet Print

Page 4

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-13RevC		Manufactured	No			200	Each	32.0000	1.0000			



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP17	-1	
46889	-1	
Main Warehouse		
ST	33	
45717	1	
46889	6	
47435	8	
48166	18	

D3566-5RevC	Manufactured	No				200	Each	23.0000	1.0000			
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Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	23	
36113	1	
46186	1	
47318	1	
48167	20	

X1 UMD 09/08/05

X1 UMD 09/08/05

W/O:		WORK ORDER CHANGES					
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D3566-1RevC		Manufactured	No			200	Each	24.0000	2.0000			



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

24

46349

1

47434

2

48165

10

48557

11

D3564-11RevD

Manufactured

No

200

Each

21.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

21

45823

1

47432

8

48553

12

July 23, 2009 7:35:46 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES						
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D3564-13RevD		Manufactured	No			200	Each	34.0000	1.0000			



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17 13

48554 13

Main Warehouse

ST 21

45409 3

46495 10

47867 8

D3564-9RevD

Manufactured No

200 Each 18.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 18

44659 1

45825 1

47316 4

48556 12

X) LMD 09/08/05

X) LMD 09/08/05

July 23, 2009 7:35:46 AM

Shop Packet Print

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 23, 2009 7:35:46 AM

Page 8

Work Order ID: 50828

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 07/23/2009

Required Date: 07/31/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD		Manufactured	No			200	Each	23.0000	1.0000			



Wearshoe

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

2

34806

2

Main Warehouse

FP19

12

48555

12

Main Warehouse

ST

9

45824

1

47433

1

48164

7

D2594-3RevC

Manufactured

No

200

Each

918.0000

16.0000



O-Ring, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

918

27168

44

29908

874

X1

UMD 09/08/05

X16

UMD 09/08/05

July 23, 2009 7:35:46 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 23, 2009 7:35:46 AM

Page 9

Work Order ID: 50828

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 07/23/2009

Required Date: 07/31/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1RevC		Manufactured	No			200	Each	716.0000	16.0000			



Plug, 205 Skidtube



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	716	
42221	16	
42807	92	
43884	103	
46435	3	
47251	502	

X
X
X

UMP 09/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. 1 SHEET 1 OF 1
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

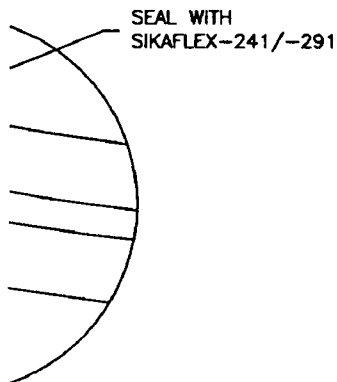
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

*[Handwritten notes: 1508 25, 06-07-93]***Copyright © 1996 by DART AEROSPACE LTD**

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Diagram illustrating the underside of a component, likely a piston, with grinding locations marked. The diagram includes the following labels and features:

- GRIND FLUSH (4 PLACES)**: Points to four locations on the outer edge of the component.
- GRIND FLUSH**: Points to a specific grinding location on the left side.
- D2576-3 STEP**: Points to a step on the outer edge of the component.
- GRIND FLUSH**: Points to a grinding location on the right side.
- LOCATION RIDGE ON UNDERSIDE OF D2576**: Points to a ridge on the underside of the component.
- 1/4**: A dimension line indicating a distance of 1/4 inch.

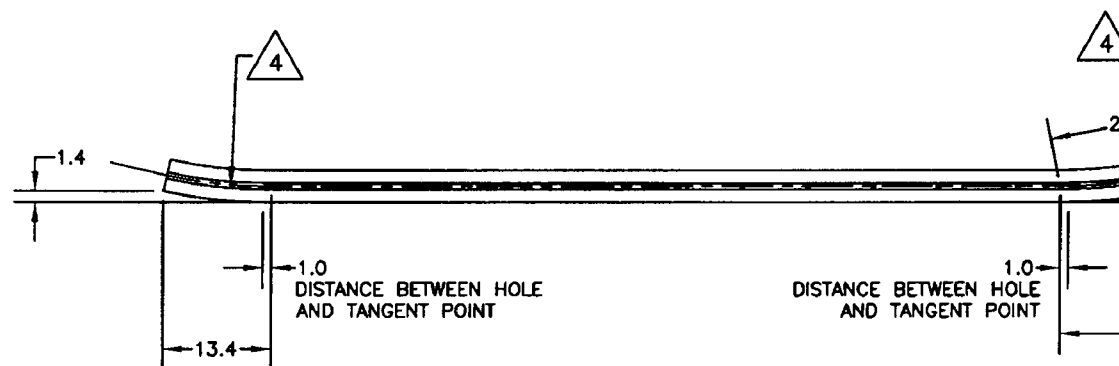


ACER

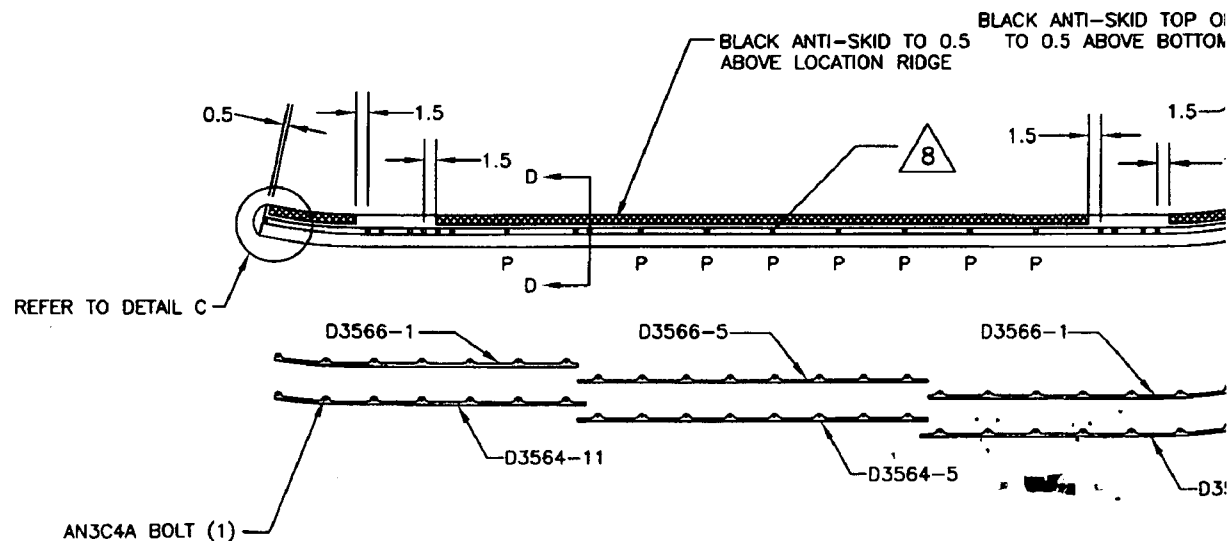
AFTER PERFORM

1. CHAM
2. INSE
3. WELD
4. CIRC

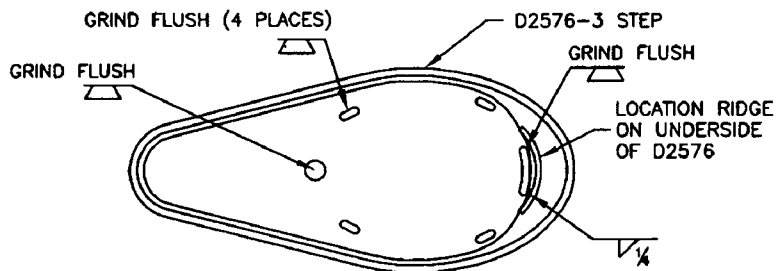
- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
 2. INSERT D2579 SPACER (20 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP



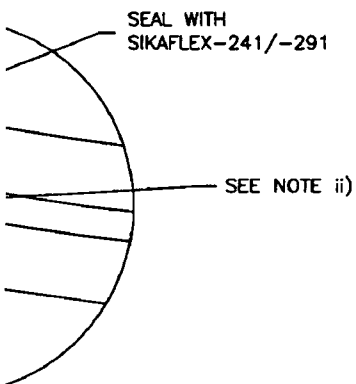
WELD AS PER D



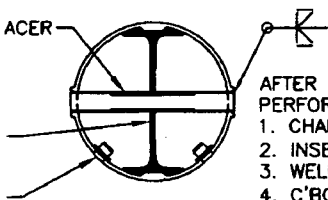
DETAIL F
SCALE 5:24



G
24

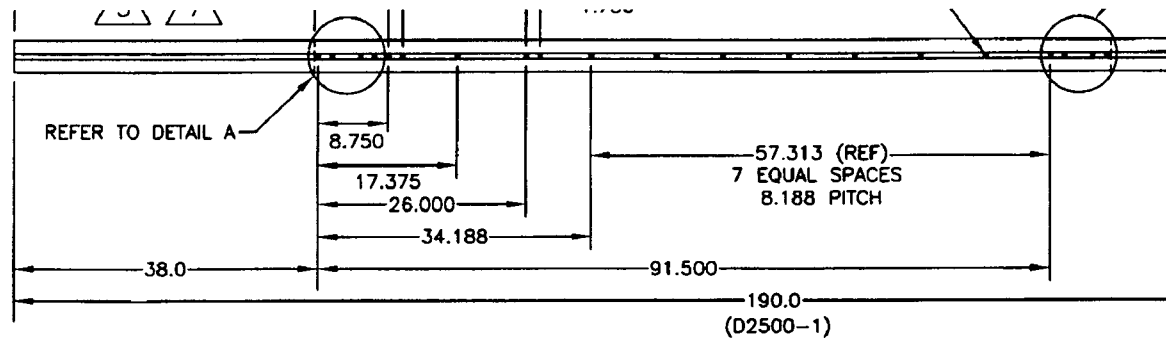


SECTION H-H
SCALE 5:24

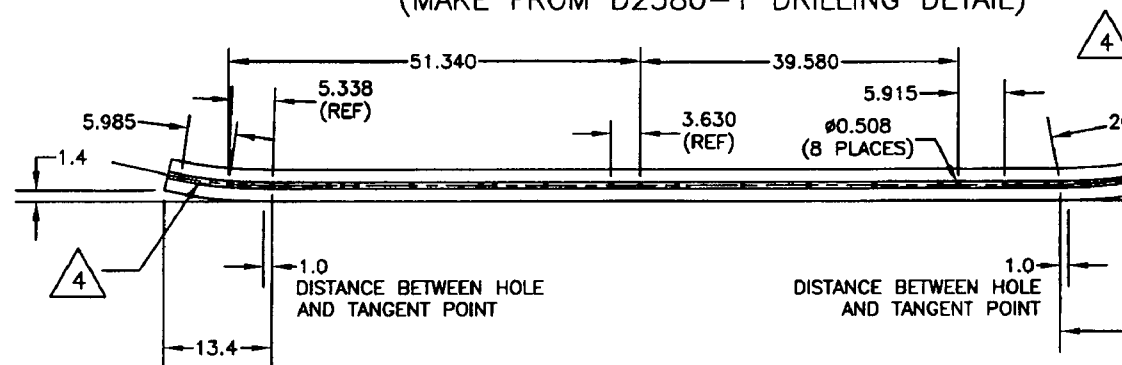


**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

- 1. CHAMFER HOLE 0.050 X 45°**
- 2. INSERT D2579 SPACER (20 PLACES)**
- 3. WELD INTO PLACE AND GRIND FLUSH**
- 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP**

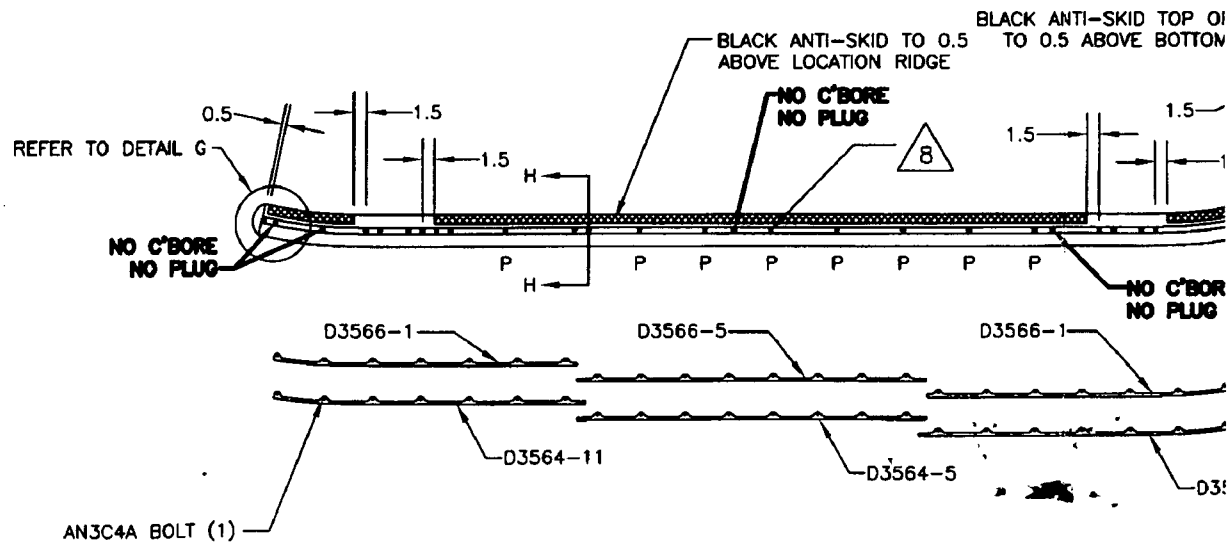


D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL

WELD AS PER D



NO. 202

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Berkeley Elliott
Job number: 48448A
Part number: D805634 041
Description: 205 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass ☒ fail ☐
pass ☒ fail ☐

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐

REFERENCE ONLY

Qualifier P. D. L. Date of Test Coupon 09-06-17
Welder Berkeley Elliott Date of Test Coupon 09-06-17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld